WOLK CLUCLID SUTSU	Work	Order II	58490
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May 7, 2010 1:44:18 PM



Page 1

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date: 07/05/2010 **Required Date: 20/05/2010**

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

QC:

Date://

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start Stop

Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours**

Draw Number Draw Rev.

Plan Code

Accept **Qty**

Reject Reject Qty Number

3/

Insp. Stamp

Draw Nbr

Revision Nbr

D2580 Rev D

100

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

110

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

Dart Ae	rospace L	.td							> •
W/O:			WC	ORK ORDER CHANG	ES				*
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-	·								
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	Res	olution:	Disposition	n:	_ QA: N/C C	losed:		Date: _	
NCR:		\	WORK ORDI	ER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC	Corrective Action		ion B	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Sect	tion C	Chief Eng	QC Inspector
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Work Order ID 58490



Page 2

Item ID:

D205-634-041

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

May 7, 2010 1:44:18 PM

07/05/2010

QC:

Start Qty: 1.00

Required Date: 20/05/2010 Reg'd Oty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Date:

Date:

Draw

Rev.

Plan

Code

Start

Reject

Qty



Sequence ID/

Work Center ID

120

Skidtubes

Skidtubes

Memo

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

Run

Stop

Stop



Insp.

Stamp

Accept

Qty

Reject

Number

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANGE	S			•	•
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	gory:	NCR: Yes	No DO	A:	Date:	<u> </u>
	R	esolution:	Disposition):	QA: N/C	Closed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:		,	WORK ORDE	R NON-CONFORMAN	ICE (NC	R)			Aug.
DATE STEP		Description of NC		Corrective Action Section		Verif	ication		Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	Section C	Chief Eng	QC Inspector
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							W. J. 740.		
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Work Order ID 58490

May 7, 2010 1:44:18 PM



Page 3

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

07/05/2010

Process Plan:

Start Qty: 1.00

Reg'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

	QC:_	

Required Date: 20/05/2010

Date:

Date:

Tooling:

SPC(Y/N):

Date:

Date:

Run

Start Stop



Sequence ID/ **Work Center ID**

140

Skidtubes

Skidtubes

Operation Description

Set Up/ **Run Hours** 0.00

Draw Number

Draw Rev.

Plan Code

Accept Qty

Qty

Reject Reject

Insp. Number Stamp

Memo

1-Weld step D2576 as per Dwg. D2580 and QSI 09-A/R□□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill A/R□□□ Aluminum Rod

M12860

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", > adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

Awm 10-5-14

W/O:			V	VORK ORDER CHANG	GES			
DATE	STEP	P	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes N	lo DQA:	Date: _	
	Resolution: Disposition:				QA: N/C Clo	sed:	Date: _	*******
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCR))		
DATE	STEP	Section A Initial Action Descrip		Corrective Action Section Description Chief Eng	sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date			
								:

Work Order ID 58490

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Page 4

Item ID:

D205-634-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

07/05/2010

Start Oty: 1.00

Required Date: 20/05/2010

Req'd Oty: 1.00



Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

SPC (Y/N):

Date:

Run

Stop



Sequence ID/

Work Center ID

150

Operation Description

QC10- Inspect visual per QS1004- ground welds

Set Up/ **Run Hours**

10/05/17

Draw Number

Date:

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

160

170

QC

Quality Control

Memo

Memo

Pressure Wash per OSI005 4.3

0.00

HandFinish

Hand Finishing

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd

cap out of solution.

1) bl 15-19

DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC	pproval C Inspector
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:	
Resolution: Disposition: QA: N/C Closed: Date:	
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
	pproval
Section A Initial Action Description Sign & Section C Chief Eng Ch	C Inspector

Work Order ID 58490

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Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

07/05/2010

Start Qty: 1.00

Required Date: 20/05/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Reject

Qty

Start

QC:

Date:

SPC (Y/N):

Date:

Draw

Plan

Code

Stop

Reject

Number Stamp

Insp.

Sequence ID/ Work Center ID

180

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114209

Set Up/ **Run Hours**

10/05/19

Number Rev.

Draw

Accept

Qty

Memo

10:30A~ START TIME: OVEN TEMPERATURE:

FINISH TIME:

190

QC3- Inspect Part Finish

Memo

0.00

0.00

0.00

Ca 10 - 05 - 21

Quality Control

	•								
W/O:			W	ORK ORDER CHANGI	ES				•
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #			Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)		,	
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	
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Work Order ID 58490

May 7, 2010 1:44:18 PM

Required Date: 20/05/2010



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Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name: Replacement Skidtube

Start Date:

07/05/2010

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Δn	prov	alc
ΛP		ais.

Process Plan: _____ Date:

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ Work Center ID

200

HandFinish

Hand Finishing

Operation Description Set Up/ **Run Hours** Draw Number

Draw Rev.

Plan Code

Accept Otv Otv

Reject Reject Number

Insp. Stamp

an 10-05 -28

Memo

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates A/R DD Sikaflex-291 DM 11/2421910

Sikaflex expire date: / O - 08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R □ □□ Sikaflex-291 □ 31/2 5/12 9

Sikaflex expire date: _/@_______

5-Wing Walk as per Dwg D2580 and OSI 005 4.4

Batch: 114432

1 Bl 10-5-25.

W/O:			W	ORK ORDER CHANG	ES				•
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	tegory:	_ NCR: Yes	No DC	A:	Date: _	
	Resolution: Disposition:				_ QA: N/C (Closed:		Date: _	
NCR:	110	V	VORK ORI	DER NON-CONFORMA	ANCE (NC	R)			
DATE STEP		Description of NC		on B	Verif	Verification	Approval	Approval	
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Work Order ID 58490

May 7, 2010 1:44:18 PM

Required Date: 20/05/2010



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Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

07/05/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Draw

Rev.

Plan

Code

Run

Number Stamp

SPC (Y/N):

Date:

Stop

Reject

Qty

Start

Insp.

Sequence ID/ **Work Center ID**

210

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Foreign objects per OSI 024

Date:

Set Up/ **Run Hours**

0.00

0.00

0.00

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Draw

Number

Accept

Qty

Reject

220

Packaging Packaging

Packaging

Memo

Memo

Identify and pack for shipping as per PPPD205-634-041

230

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/3194) MF

W/O:			W	ORK ORDER CHANG	ES			•
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes 1	No DQA:	Date: _	
Resolution: Dis								
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DATE	CTED	Description of NC	Corrective Action Section			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		,		1				

Parent Item Name: Replacement Skidtube Comments: IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM D2580-1 Manufactured No 110 Each 9.0000 1 LG 9 Loc Code LG 9 Loc Code 1797 8 2 1799 8 3 12 179 8 3 12 1799 8 3 12 1799 8 3 12 1799 8 3 12 1799 8 3 12 179 8 3 12 1799 8 3 12 1799 8 3 12 1799 8 3 12 1799 8 3 12 179	•						
Work Order ID: 58490	Picklist Print	t					Dona 1
Parent Item: D205-634-041	May 7, 2010 1:44:	22 PM					Page 1
Parent Item: D205-634-041	Work Order ID: 58	8490					
Replacement Skidtube Skart Date: 07/05/2010 Required Date: 20/05/2010 Requ	Parent Item: D	0205-634-041					4
IPP Rev:No 0.02.82 Start Qty: 1.00 Required Qty: 1.00 IPP Rev 1.00.219 per PAR09-043 EC verified by:DD IPP Rev 0.02.28 Added paperwork EC IPP Rev:P 0.7-07-09 Start Qty: 1.00 Required Qty: 1.00 IPP Rev:P 0.02.28 Added paperwork EC IPP Rev:P 0.7-07-09 Start Qty: 1.00 Required Qty: 1.00 IPP Rev:P 0.000 IPP Rev:P	Parent Item Name:	Replacement Skidtube	11621	''- 'BIS KEN BEID BIN KEELS BIIRS INN BIBN I		Start Date: 07/05/2010	Required Date: 20/05/2010
Location Loc Oty Loc Code	Comments:	IPP Rev P 10.02.19 p IPP Rev. O 06.02.28	per PAR09-043 EC Added paperwork	verified by:DD EC	ìKJ	Start Qty: 1.00	-
D2576-3 Manufactured No 140 Each 110.0000 1 Location Loc Oty Loc Code	D2580-1		anufactured No		110 Each		
Location Loc Oty Loc Code	D2576-3	IBBS ((() 186)	B59 anufactured No	LG 57028 57347 57902 57938 58090	9 1 1 1 2 2 2	110.0000 1	
	Step (maching detail)						•
$\begin{array}{cccccccccccccccccccccccccccccccccccc$						Loc Code	
							- B.F. 10/05/12

		Location	Loc	<u>Oty</u>	Loc Code			
		LG		110			 	
		46661		62		_	BE 10/04/12	
		52215		48		_	 / /	
D2579	Manufactured 1	No	140	Each	193.0000	20		
					{ 			

Crossbolt Spacer

Location Loc Oty Loc Code LG 193 57052 13 57348 180

	•									
W/O:			WC	RK ORDER CHAN	GES				•	
DATE	STEP	PRO	DCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	Part No: PAR #: Fault Category:									
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NCR:		•	WORK ORDI	ER NON-CONFORM	IANCE (NCF	?)				
DATE	STEP	Description of NC		ection B	cation	Approval Approva	Approval			
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Work Order ID: 58490

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

Purchased

Purchased

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

Start Date: 07/05/2010

Required Date: 20/05/2010

bk10-5-25

Start Qty: 1.00 Required Qty: 1.00

D2855

Manufactured No

200

Each

105.0000

Cap

	Location		Loc Qty	Loc Code
	FP6	į	2	
- 2 -	560	₹	2	i
	ST026		103	
	50513	3 *	1	
	50770) /	29	
	51539		19	
	53791	!	54	
No		200	Each	963.0000

Bolt

AN3-5A

Location	
ST350	
	105057

Loc Oty 963 963 200 Each

Loc Code

4,297,000

AN960JD10L

Washer

Insert

Location ST348

110985

Loc Oty 4297 4297

Each

Loc Code

ALS7-1032-130 Purchased

> Location ST282

Loc Qty 17

17

Loc Code

17.0000

ALS4-1082-130 May 7, 2010 1:44:22 PM

No

No

113238

200

Shop Packet Print

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				. 5
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty Chie	oroval of Eng / od Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA:	D	ate: _	
	R	esolution:	Disposition	on:	_ QA: N/C	Closed:	D	ate: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verifica	tion App	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Section		ef Eng	QC Inspector
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Picklist Print

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Page 3

Work Order ID: 58490

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets



Start Date: 07/05/2010

Required Date: 20/05/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

200

Each

1,939.000

50

BOLT

Location	Loc Oty	Loc Code
ST350	1939	
114103	501	
114108	300	
114416 114523	138	
114523	1000	

AN960C10L

Purchased

No

200 Each

0.0000

33.0000

50 Bk 10-5-25

NAS 1149003322 D3566-13

Gasket

washer

114 341

Each

D3566-5

Gasket

Manufactured No

Location Loc Oty Loc Code FP 33

33 200 Each

21.0000

Hel 10-5-25.

Location Loc Qty Loc Code FP015

21 57526 1 57682 c 20

W/O:			V	VORK ORDER CHANGE	S				s ⁴ an	
DATE	STEP	PROCI	EDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:								
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NCR:		. WC	ORK OR	DER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval	
DATE	SIEP	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector
				:						

Picklist Print

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Page 4

Work Order ID: 58490

D205-634-041



JLM

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

Start Date: 07/05/2010

Required Date: 20/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1

Manufactured

Manufactured

Manufactured

No

No

200

200

200

Each

41.0000

2

Gasket

Location

FP015

58182

Loc Qty 41 20

21 Each

9.0000

27.0000

Loc Code

H 10-5-25

D3564-11

Wearshoe

Location

FP019

57957

Loc Qty

Loc Qty

27

12

14

9 Each Loc Code

Bl 10.575

D3564-13

Wearshoe

Location

FP17

56533 576842 57922

Loc Code

W/O:			WC	ORK ORDER CHANG	ES				,	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	•	Date:		
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NCR:	10.41		WORK ORD	ER NON-CONFORMA	NCE (NCF	1)				
DATE	STEP	Description of NC			Verification			Approval	Approval	
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Picklist Print

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Page 5

Work Order ID: 58490

D205-634-041



Replacement Skidtube



Parent Item:

IPP Rev:N \square 02.08.28 \square FP was QC5 in Step 27; Added QC5 to Step 30 \square KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM



Start Date: 07/05/2010

Required Date: 20/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-9 # (**63**/48 1**556** 148 148 2014 2014)

Manufactured No 200

Each

22.0000

I TANGATAN TANON TATAN MATAN MATAN MATAN TATAN	
Wearshoe	

Locatio	<u>n</u>	<u>Lo</u>	c Oty	Loc Code
FP			1	
	55334		1	
FP019	/		21	
	57685		7	
	57958		14	
		200	Each	7 0000



Wearshoe

Manufactured

No

Location

34806

57525

FG

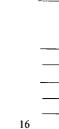
FP19



Loc Otv

Loc Code





D2594-3

O-Ring, 205 Skidtube

Manufactured No 57729

200

Each

407.0000



Location Loc Qty Loc Code FP 407 55546 19 581914 388

16. Bk 10-5-25

W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cateç	gory:	NCF	R: Yes	No DQ	A :	_ Date: _	
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DATE	STEP	Description of NC	}		ction B	Cian 0		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

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Page 6

Required Date: 20/05/2010

Required Qty: 1.00

Work Order ID: 58490

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

D2594-1

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

Manufactured

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09

Added paperwork EC SS Wearplates & Gaskets

No

JLM

200

Each

382.0000

16

Start Date: 07/05/2010

Start Qty: 1.00

Plug, 205 Skidtube

<u>Location</u> FP

> 42807 55002 57826 **4**

Loc Qty

382

112

128

142

Loc Code

<u>c couc</u>

16 pl 10-5-25.

Dart Aerospace

W/O:			W	ORK ORDER CHAN	GES							
DATE	STEP	F	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
·									7			
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Ye	s No DC	A:	Date:				
		Resolution: Disposition:										
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NO	R)						
DATE	STEP	Description of NC	Description of NC Corrective Action		Ve			Verification Approval				
- DATE	JOIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		tion C	Chief Eng	Approval QC Inspector			
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DESI	SN ##	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KEDWL	APPROVED	DRAWING NO. REV. D
			D2580 SHEET 1 OF 3
DATE			TITLE SCALE
07.	02.27		205 SKIDTUBE ASSEMBLY NTS
Α		96.09.16	NEW ISSUE
В		96.12.02	AS MANUFACTURED
С		98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183



QTY -041	QTY -045	Part Number	Description	7
Х		D2580-041	SKIDTUBE ASSEMBLY	7
	Х	D2580-045	SKIDTUBE ASSEMBLY	
1	1	D2500-1-190	EVERIOUS	
1	1	D2576-3	EXTRUSION STEP	
20	24			⊣
16		D2579	CROSS BOLT SPACER	PHOs COSA
	16	D2594-1		SUCCOL .
16	16	D2594-3	O-RING	RITURNITO
1	1	D2596	205 WEB	EN JINEERING
	1	D2855	AFT CAP LINCO	M. ROLLID CODY
1	1	D3564-5	WEARSHOE	TO AMENDMENT
1	1	D3564-9	WEARSHOE SUBJE	HOUT NOTICE
11	1_	D3564-11	WEARSHOE "	WORK ORDIN
1	1	D3564-13	WEARSHOE	KK ZHOO
2	2	D3566-1	GASKET NO	307-10
1	1	D3566-5	GASKET	7 0,607
1	1	D3566-13	GASKET	RK ORDER 58490 880-5-07
50	50	ALS7-1032-130	INSERT	7
		or AKS7-1032-130		
į		or AKS4-1032-130		
		or AELS-1032-130	<u>i </u>	
50	50	AN3C4A	BOLT	7
2	2	AN3-5A	BOLT	7
50	50	AN960C10L	WASHER	7
2	2	AN960JD10L	WASHER	–

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

SEE NOTES ON

PAGE 2 FOR D2580-041 AND PAGE 3 FOR D2580-045

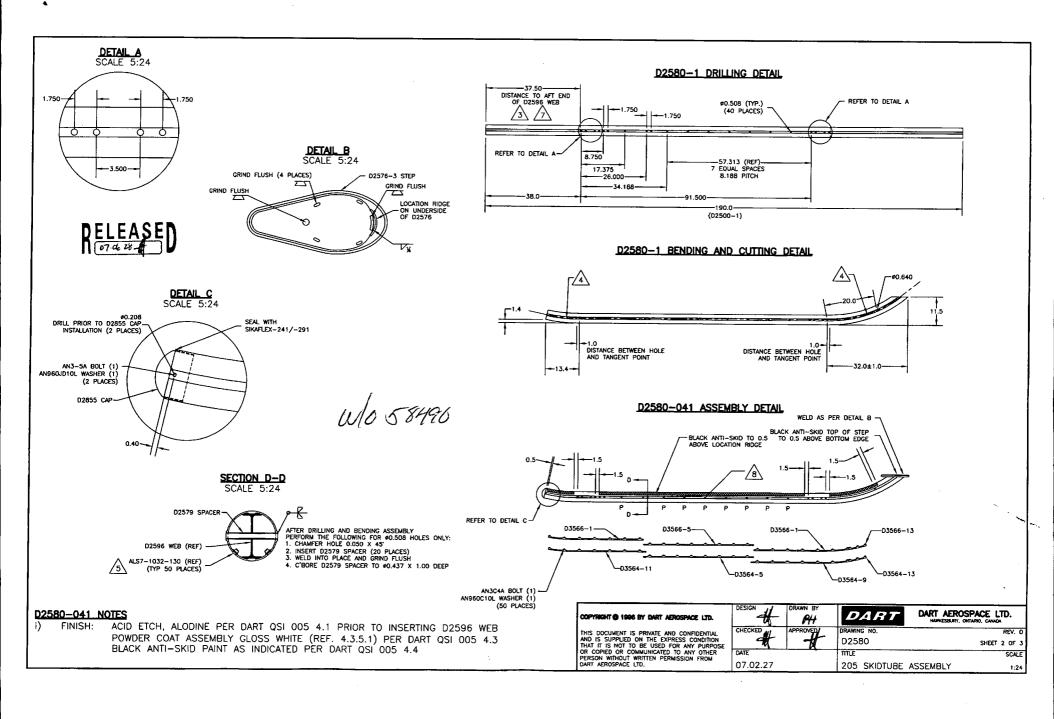
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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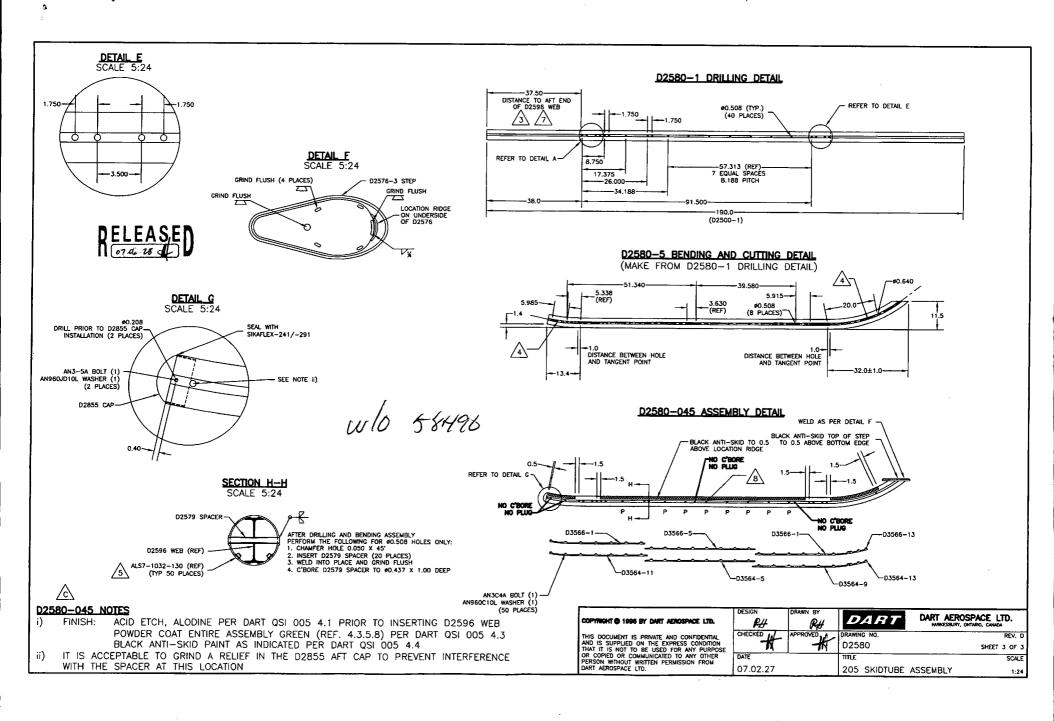
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W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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							··· ••••••			
Part No	•	PAR #:	Fault Cate	gory:	NCF	R: Yes	No DQ	4 :	Date:	
	R	solution: QA: N/C Closed:						Date:		
NCR:			WORK ORDI	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action Sec	ction B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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W/O:			WO	RK ORDER CHANGE	ES			•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Res	solution:	Disposition	1:	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	3)		
DATE		Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							;	



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W/O:			W	ORK ORDER CHANG	GES					•
DATE	STEP	PR	OCEDURE CH	ANGE	ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-							:		•

Part No	:	PAR #:	Fault Cate	egory:	NCR:	Yes N	lo DQ	4 :	Date: _	
				Disposition:				Date:		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)			_	
DATE	STEP	Description of NC	Initial		ction B	Sign &	Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
							:	_		
		igati								
: ****										

NO.____

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name:	tarion Eliate	
Job numb	ber: <u>Anges C</u>	
Part num	iber: 5305 - 634 041	
Description	on: 205 okid Aubs	
Welding 1	Process: Tig[] Mig[]	
Base mat	eriel: Aluminium	
Current:	AC[] DC[]	
	·	

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[] fail[] pass[] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Welder	Date of Test Coupon 10.00.2

The above named individual is qualified in accordance with AWS D17.1.2001 to weld